Green Tier Application

State of Wisconsin
Department of Natural Resources
PO Box 7921,
Madison WI 53707-7921
Form 4800-022
dnr.wi.gov

Revision 05/2005

Notice: Collection of this information is authorized under s. 299.83 Wis. Stats. Participation in Green Tier and completion of this form are voluntary. Personal information collected on this form, including such data as your name, address, phone number, etc., will be used in the implementation of Green Tier and will be made broadly available under the Green Tier program. Information will also be made accessible to requesters under Wisconsin's Public Records Law (ss. 19.32 -19.39, Wis. Stats.). Applications must be considered complete by the Department of Natural Resources in order to be processed. For application instructions, see "Green Tier Application Instructions," publication number CO-501.

This application is a: ☒ **Tier 1 Participation Request** ☐ **Tier 2 Participation Request**

I. Applicant Information (add additional forms for each entity that is part of the applicant group)

Person or Entity Name		Title	
Times Printing Co Inc/ Wendy Scholler		EHS Director	
Street Address	City	State	Zip Code
100 Industrial Drive	Random Lake	WI	53075
Telephone Number	Fax Number	E-mail Address	
920-994-4396	920-994-2302	wendy.scholler@timesprintingco.com	

II. Facility Information (add additional forms for each facility or activity that is to be included in Green Tier)

Facility Name		SIC/NAICS Codes	County
Times Printing Co Inc		2752	Sheboygan
Street Address	City	State	Zip Code
100 Industrial Drive	Random Lake	WI	53075
Mailing Address	City	State	Zip Code
P.O. Box 325	Random Lake	WI	53075
Please identify all DNR Facility Identification numbers (FID#s) that apply to the covered facility or activity			
460086990			

III. Scope of Green Tier Participation (Materials in support of this section should be labeled Attachment 1.)

Is this application to cover all activities at the facility? ☒ Yes ☐ No If no, please describe the discrete activities to be covered in the program.

IV. Enforcement Record (Materials in support of this section should be labeled Attachment 2. Eligibility requirements are established in s. 299.83(3) and (5), Wis. Stats.)

Has the applicant, managing operators of the applicant or any person with 25% or more ownership interest in the applicant:

Yes No
☐ ☒ a. Had a judgment entered against them, or been convicted of a criminal violation of an environmental regulation involving a covered facility or activity? If yes, please provide the date(s) of the judgment or conviction and the nature of the violation(s).

Applicants convicted of a criminal violation within 60 months of the date of the application for Tier 1 or 120 months for Tier 2 are ineligible for the program.

☐ ☒ b. Had a civil judgment entered against them for a violation of an environmental regulation involving a covered facility or activity? If yes, please provide the date(s) if the judgment and the nature of the violations.

Applicants with a civil judgment entered against them within 36 months of the date of the application for Tier 1 and 60 months for Tier 2 are ineligible for the program, unless the applicant requests a waiver of this prohibition under s. 299.83(3)(e) or (5)(e) .

☐ ☒ c. Been referred to the Department of Justice for enforcement of an environmental regulation involving a covered facility or activity? If yes, please provide the date(s) of referral and the nature of the violation(s).

Applicants referred to the Department of Justice within 24 months of the date of the application for Tier 1 or Tier 2 are ineligible for the program, unless the applicant requests a waiver of this prohibition under s. 299.83(3)(e) or (5)(e).

Yes No
☐ ☒ d. Been issued an environmental citation by the Department of Natural Resources involving a covered facility or activity? If yes, please provide the date(s) of the citation and the nature of the violation(s).

Applicants issued an environmental citation within 24 months of the date of the application for Tier 1 or Tier 2 are ineligible for the program, unless the applicant requests a waiver of this prohibition under s. 299.83(3)(e) or (5)(e).

Are you requesting a waiver under s. 299.83(3)(e) or (5)(e)?

Yes No
☐ ☒ **If yes, please attach a justification. Waivers may be granted in exceptional circumstances.**

V. Environmental Performance

Please provide information about, and examples of, your superior environmental performance. In answering this question, please separately address A) past and present superior environmental performance; and B) proposed (future) superior environmental performance. (You

must address both A & B in your application.) Materials in support of this section should be labeled Attachment 3. For definitions of *environmental performance* and *superior environmental performance*, refer to the Application Instructions. In addition, for either a Tier 1 or Tier 2 application, you will be asked to provide a baseline of environmental performance against which future performance will be measured. Please provide potential indicators that would be used for that baseline.

VI. Environmental Management System (EMS)

Materials in support of this section should be labeled Attachment 4.

Yes	No	
☐	☒	a. Do you have an EMS certified to the International Organization for Standardization (ISO) standard 14001?
☐	☒	b. Do you have an EMS that is functionally equivalent as determined by the Department of Natural Resources?

If no to both questions, you are not eligible ffor Tier 2 status. If you are applying for Tier 1 status, you will need to develop a functionally equivalent EMS within one year from the date of acceptance of this application.

If yes to either question, please attach a copy of the following to this application:

- Your facility's EMS (or provide an electronic link to your EMS)
- Third party certification
- Functional equivalency determination, addressing each of the 12 elements defined in s. 299.83(1)(dg)

VII. Stakeholder Identification

Please provide a list of stakeholders who could be interested in your application. Include in your list names and addresses of the following classes of people: neighbors, suppliers, customers, local environmental group representatives, local governments, waste contractors, wastewater utility, and any other individuals or groups which you believe might have an interest in your application. This list of stakeholders should be submitted as Attachment 5.

VIII. Tier 1 Applicant Statement of Commitment

I commit to:

a. Implement, within one year of the date of acceptance of this application, an EMS that is third party certified or is functionally equivalent as demonstrated by a matching up of the requirements in s. 299.83(1)(dg) and elements of the EMS.
b. Conduct annual EMS audits, with at least every third audit performed by an independent environmental auditor approved by the Department of Natural Resources.
c. Submit to the Department of Natural Resources an annual report on the EMS audit that is in compliance with s. 299.83(6m)(a) and documents progress towards meeting objectives related to improved environmental performance, including the submission of indicators agreed on by the parties.

I commit to the above statements and certify that all information provided is true and correct under penalty of law.

Signature of Applicant	Date Signed
Jack Schalk	6-9-05

IX. Tier 2 Applicant Statement of Commitment

I commit to:

d. Conduct annual EMS audits performed by an independent environmental auditor approved by the Department of Natural Resources.
e. Conduct, or have another person conduct an annual audit of compliance with environmental requirements that are applicable to the covered facilities and activities that are the subject of this application.
f. Submit to the Department of Natural Resources an annual report on the EMS audit and the environmental requirements compliance audit that is in compliance with s. 299.83(6m)(a) and documents progress towards meeting objectives related to improved environmental performance, including the submission of indicators agreed on by the parties.

I commit to the above statements and certify that all information provided is true and correct under penalty of law.

Signature of Applicant	Date Signed
Jack Schalk	6-9-05

Attachment # 3

Times Printing Co Inc is a general commercial and periodical publication lithographic printer with one manufacturing location in Random Lake, Wisconsin. Times Printing has six web presses, six sheet-fed presses, finishing operations: including bindery and mailing, and pre-press operations.

The company was established in 1918, originally started as a local newspaper called the "Random Lake Times". Since then, the company has grown as a family owned and managed business for the past 86 years. Major expansions took place in the early 1990's, moving the plant to a new location just off of state Hwy 57 in a newly established industrial park. The building that the company is housed in now spans over 390,000 square feet.

The project that we undertook in the last year and a half was the replacement of 3 catalytic oxidizers, and the installation of one Regenerative Thermal Oxidizer (RTO). An RTO is used to eliminate exhaust given off by the large ink drying ovens used in the offset printing process. The benefits of this project were numerous, including probably the largest savings coming in the cost of operation and energy usage. The three catalytic oxidizers that have been in use since the early to mid 1990's were a HXC 1, HXC 2, and AEI catalytic oxidizer. Each HXC oxidizer was calculated as costing $26,245/yr to run during up time, and $8750/yr in idle mode. The AEI oxidizer was calculated as costing $76,953/yr during up time, and $22,300/year in idle mode. The total operating cost for the 3 units in gas and electric topped $169,243/year. The total operating cost for gas and electric for the new RTO installed in late August 2004 is just under $20,000/year.

The RTO has a 99%+ VOC destruction efficiency compared to 97% with the best of the three old catalytic oxidizers, and that was immediately after a catalyst change. The destruction efficiency of a unit like the RTO is measured in how much of a pollutant (VOC's in

this case) can be controlled or cleaned out of the exhaust before going out to atmosphere.

To understand how the process works, and why there is such a dramatic energy savings, I have laid out the route the air that is contaminated with volatile organic compounds (VOC) from press solvents takes. This process is similar to the way a catalytic converter works on your vehicle.

> The air is forced into the RTO inlet and is directed into one of the energy recovery canisters. The VOC laden air passes vertically upward through the first of the two heat exchanger canisters where it absorbs heat from the ceramic media (thus cooling the media). The preheated air then enters into the combustion chamber (typically at a temperature very close to the temperature required for oxidation) where it is heated further to 1500 degrees Fahrenheit and held at this oxidation temperature for a period of time sufficient to achieve a high VOC destruction efficiency. The clean (hot) air then passes from the combustion chamber vertically downward through the second energy recovery canister. Heat generated during VOC oxidation is then absorbed by the ceramic media (thus heating the media). The clean (cooled) air is routed to atmosphere. To attain the high destruction efficiency, additional switching valves are required. These valves direct process air to a holding chamber while the main valves are switching the airflow direction in the media canisters. The process air in this chamber is then returned to the fan inlet and treated in the oxidizer. When destructed, the VOC's in the exhaust stream become fuel for the oxidizer.

The major difference between the process of your vehicles' catalytic converter and this RTO unit is that instead of the air going out to exhaust after being cleaned the first time at much lower destruction efficiencies, it recycles itself and utilizes the energy from the pollutant to run another cycle through the system, in turn allowing the unit to run as efficient as possible before exhausting 99%+ clean air to atmosphere.

Along with the RTO project, there were two waste minimization projects that the company put together. The first project was a waste

absorbent (absorbent socks and pads) recycling program. We partnered with CRI Recycling to have our waste oil absorbents recycled. This process is a closed loop recycling process where CRI Recycling takes the waste oil absorbents and processes them through a multi-step filtering process where oil is taken out and used for refined oil, marine fuel or low grade lube stock. The absorbent pads are recycled and made into absorbent socks and the inside of the socks are recycled and used for granular oil absorbent. In many instances, the polypropylene is recycled and sent to a manufacturer in Florida to make basketball hoops. CRI Recycling then sends us back the recycled absorbent socks to be used again.

The second waste minimization project came in the form of recycling our press inks with American Re-Fuel. They are the leading providers of waste to energy services in the northeastern United States. They specialize in converting municipal solid waste, instead of using coal and other natural resources, into energy in the form of steam and electricity. We had spent a lot of time testing out different recycling processes with different companies, and we always seemed to run into a problem with the ink's quality the second time around. As a company, we wanted to find a source where this waste ink could be utilized a second time around instead of being incinerated. We started to work with a company called Enviro-Safe and they proposed working with American Re-Fuel.

The company is making an organized effort throughout the plant to look at waste minimization and better ways to run our business. To site a small example from within a department, we eliminated use of a volatile solvent in the mailing department, and replaced it with a product called Orange-Sol, a cleaning solvent based from orange oil that works great on glue applications and plastic clean up. Each department not only looks at cost now, but also at what the impacts of change will be on environmental, health, and safety issues. The RTO was a big step for us in the right direction to reducing energy usage, waste and overall impact to the environment and the safety and health of our employees and neighbors.